

Work Order ID 103788

June-26-13 10:14:03 AM

\*103788\*

Page 1

Item ID: D3211-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket for Interior Window for -015 & -025  
 Start Date: 6/26/13 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 7/01/13 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3211	B

100	FLOW WATER JET	0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3211 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								

12 EL 13-6-26

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

12 EL 13-6-26

120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

(12) 13-06-27 DAS  
09  
2-88

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
*130*	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140		0.00							
*140*	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend D3211-1 Stack as per Dwg D3211								
150		0.00							
*150*	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

N/A

SB  
13/06/27

21

13627

12

12

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Item ID: D3211-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket for Interior Window for -015 & -025

Start Date: 6/26/13 Start Qty: 12.00 \*12\*

Cust Item ID:

Required Date: 7/01/13 Req'd Qty: 12.00 \*12\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Chemical Conversion Coat per QSI005 4.1 0.00

\*160\*

HandFinish

Memo

Hand Finishing

170 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

\*170\*

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

180 QC3- Inspect Part Finish 0.00

\*180\*

QC

Quality Control

Memo

180 QC3- Inspect Part Finish 0.00

\*180\*

QC

Quality Control

Memo

12x f 13/06/27

12x f m/f 13/06/27

12 f B-0-08

W123480

3:15  
3200F  
3:45

# Work Order ID 103788

**\*103788\***

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Item ID: D3211-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Start Date: 6/26/13 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 7/01/13 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>ST211</u>  Memo	0.00  0.00				<u>12x</u>		<u>17.10.13-06-28</u>	
200 <b>*200*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						<u>17.13-06-28</u>  <u>17.13-06-28</u>	

# Picklist Print

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Work Order ID: 103788

Parent Item: D3211-1

Start Date: 6/26/13

Required Date: 7/01/13

Parent Item Name: Bracket for Interior Window for -015 & -025

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-17 JLM  
IPP Rev:B Now on Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	552.8489	1.405	17.747368			

17.747368  
13-6-26

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	552.8489	
119916	0.2	
121197	21.34	
123096	11.4	
123654	11.64	
123701	45.8289	
125341	89.44	
<u>125636</u>	373	

25'

9.3

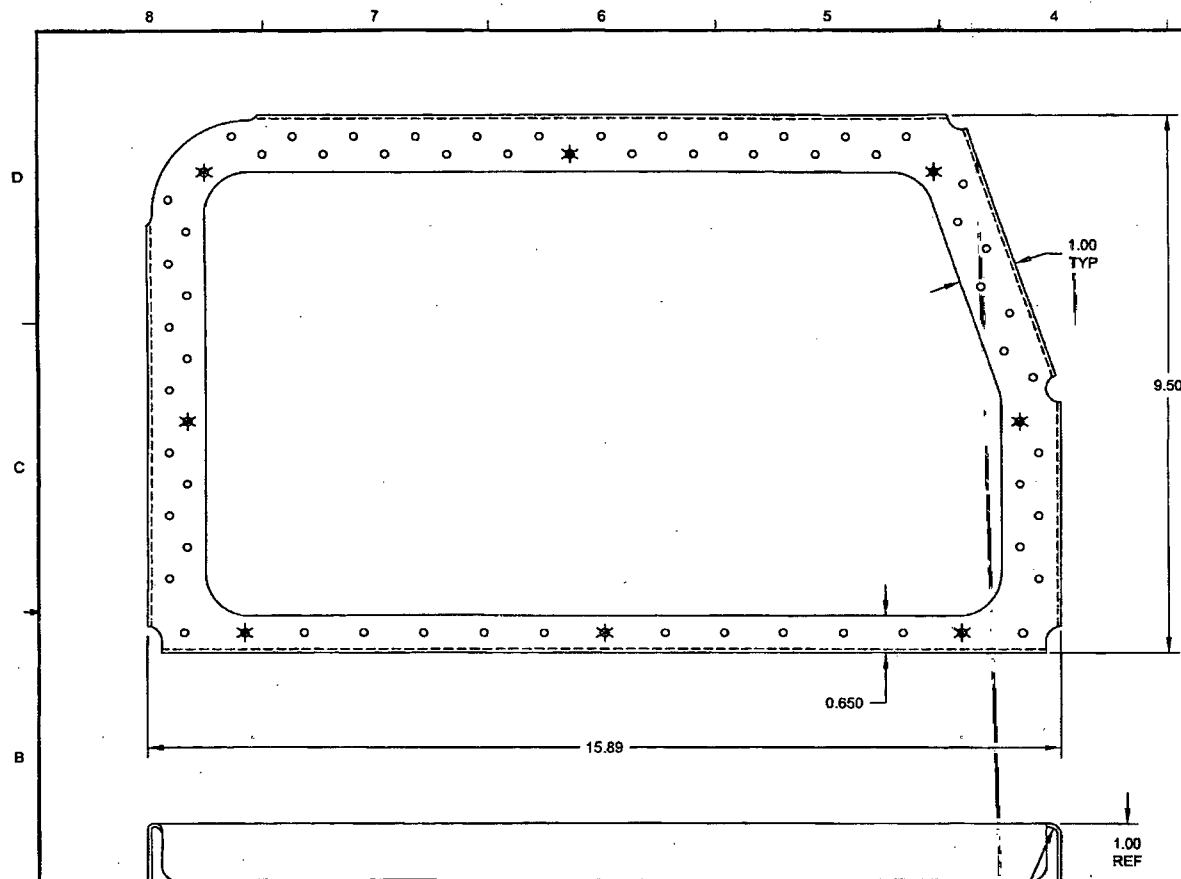
103788

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>DL</i>	Audited by:	<i>DL</i>	Preliminary Approval:	
Date:	<i>13-6-26</i>	Date:	<i>13-06-27</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	12.02.01	Dwg Rev updated	KJ	



**D3211-1 DOUBLER**  
(MAKE FROM D3211-1F)  
(D3211-1B SIMILAR, MAKE FROM D3211-1BF)

R0.125 BEND RADIUS  
TYP

**D3211-1/-1B NOTES:**

- 1) MATERIAL: MAKE FROM D3211-1F OR D3211-1BF AS APPLICABLE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.49 lbs

*WLO 103708*

**RELEASED**  
2011-06-14

B	FORMAT TO NEW STD; INCORP. REV. A1 AND DEO: ADDED D3211-1/-1BF. REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.06		

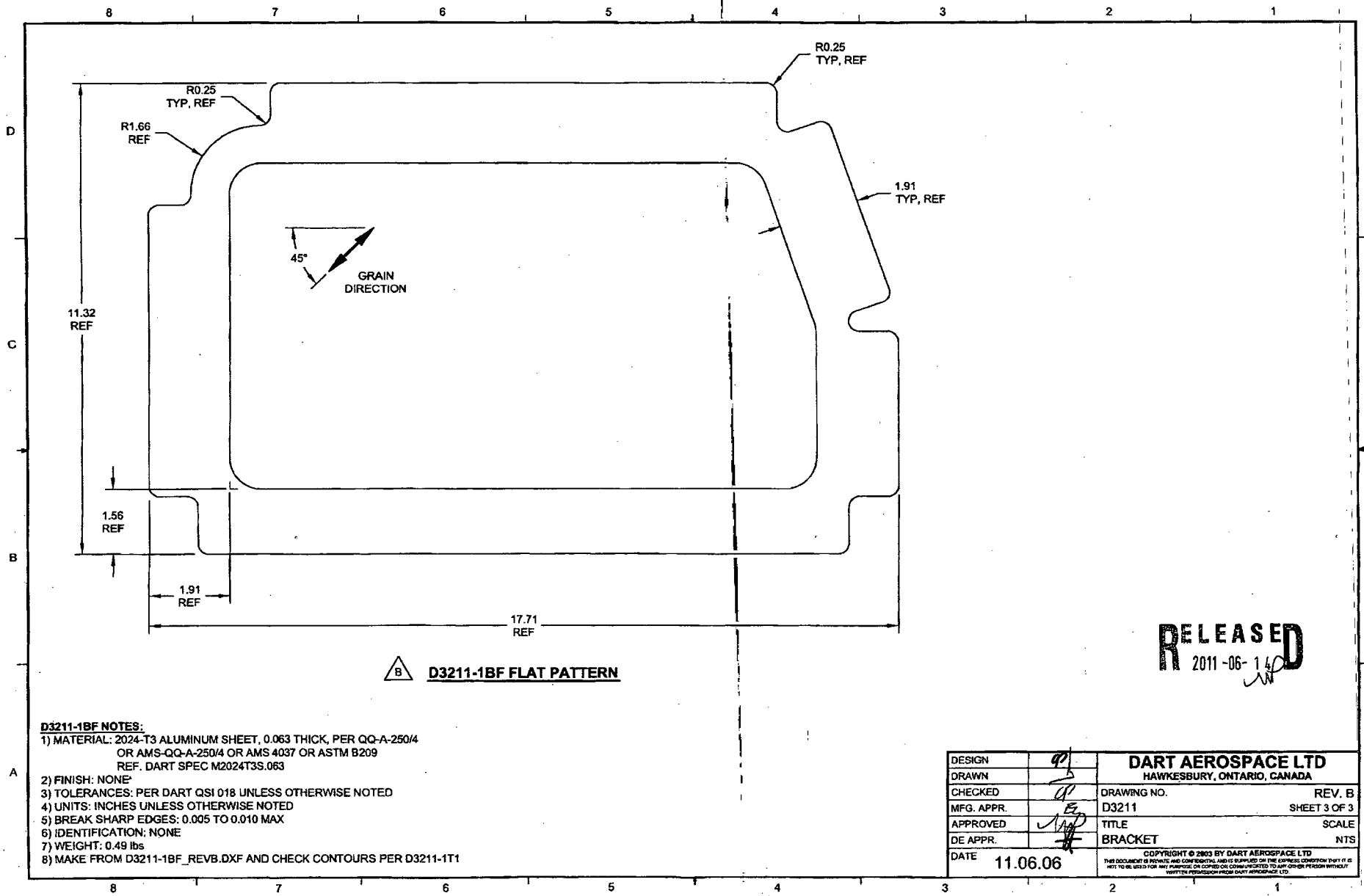
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3211  
TITLE BRACKET  
REV. B  
SHEET 1 OF 3  
SCALE  
NTS

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**D3211-1BF FLAT PATTERN**

**RELEASED**  
2011-06-14

**D3211-1BF NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4  
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF. DART SPEC M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs
- 8) MAKE FROM D3211-1BF\_REV.B.DXF AND CHECK CONTOURS PER D3211-1T1

DESIGN	91	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3211	SHEET 3 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BRACKET	NTS
DATE	11.06.06	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	